

6061

0.500 x 0.058

Work Order ID 141110

141110

Page 1

January 26, 2016 3:54:03 PM

Item ID: D4202-1 Accept *N9000040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Spacer

Start Date: 1/26/2016 Start Qty: 200.00 *200*

Required Date: 2/10/2016 Req'd Qty: 200.00 *200*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: SA Date: 20160126 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4202	C

100	Hardinge CNC LATHE SMALL	0.00							DAS 40 9-89
-----	--------------------------	------	--	--	--	--	--	--	-------------------

100

Hardinge

Hardinge CNC Lathe Small

Memo

1- Machine as per Folio FB015

FOLIO REV: AA

DWG REV: C

0.03

205 $\emptyset$

16/02/03

DO NOT CHAMFER OUTSIDE DIA

2- Deburr

110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 40 9-89
-----	---	------	--	--	--	--	--	--	-------------------

110

QC

Quality Control

Memo

0.03

205 $\emptyset$

16/02/03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																	
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DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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		OTHER : ☐							

Work Order ID 141110***141110***

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January 26, 2016 3:54:03 PM

Item ID: D4202-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 1/26/2016 Start Qty: 200.00 ***200*** Cust Item ID:
Required Date: 2/10/2016 Req'd Qty: 200.00 ***200*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>LG001</u>	0.00							
190									
Packaging	Memo	0.03							
Packaging	***STOCK IN SKIDTUBE CELL*** LOCATION : LG001								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.33							
Quality Control									

FEB 23 2016

MCS

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		OTHER : ☐							

Picklist Print

January 26, 2016 3:54:08 PM

Page 1

Work Order ID: 141110

141110

Parent Item: D4202-1

D4202-1

Parent Item Name: Spacer

Start Date: 1/26/2016

Required Date: 2/10/2016

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP REV:A NEW ISSUE 10-12-07 JLM VERIFIED:DD IPP
REV:B AS PER REV B 11-04-05 JLM VERIFIED BY:DD IPP Rev:C
11.12.19 PER DWG REV.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.058		Purchased	No			100	f	92.6600	0.35	73.68421			

M6061T6T0 500W 058

6061-T6 RD Tube .500 x.058W

**

16/02/03

DAS
40
9-89

Location

Loc Qty

Loc Code

MAT

92.66

→ m133043

8.66

→ m133400

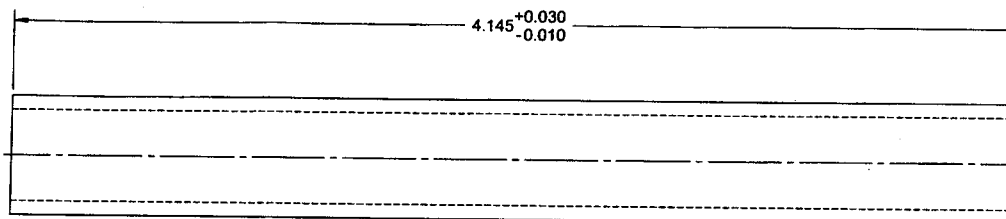
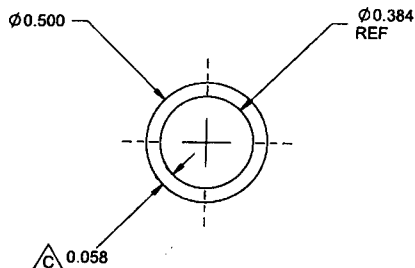
84

→ 134138

11, 2
18

48

Couldn't pull Material.
There is no "133400" material left.



D4202-1 SPACER

RELEASED
2011-12-14

20160126 SH 140110

- NOTES:**
- 1) MATERIAL: 6061-T4/T42 ALUMINUM TUBING PER WW-T-700/6, AMS 4081, OR ASTM B210 / B221 / B241
REF DART SPEC M6061T4T0.500W.058
OR
6061-T6/T62 ALUMINUM TUBING PER WW-T-700/6, QQ-A-200/8, QQ-A-225/8, AMS 4080 / 4082, OR ASTM B210 / B221 / B241
REF DART SPEC M6061T6T0.500W.58
HEAT TREAT TO -T4/-T42 CONDITION. MIN UTS = 30 KSI (60 HREW MIN)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

C	6061-T4 WAS 6061-T6, 0.058 WAS 0.049	CP	11.12.13
B	0.049 WAS 0.058. REASON: FACILITATE MFG	MB	11.03.22
A	NEW ISSUE	CP	10.09.22
REV.	DESCRIPTION	BY	DATE
DESIGN	JD	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JD		
CHECKED	ALS		
MFG. APPR.	EF		
APPROVED	EF		
DE APPR.	EF	SPACER	
DATE	11.12.13	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REV. C
SHEET 1 OF 1
SCALE
NTS

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
308421	1	108815

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

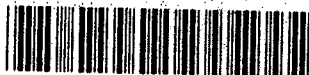
DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

LIVRÉ À /Shipped To

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
31271		AL-6061	2016/2/8	fed
QUANTITÉ Quantity	No. PIÈCE Part No.	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight

205 D4202-1

(205) D4202-1 SPACER

1 BOITE DE CARTON

7,4

14/2/22
SD

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

CERTIFICAT

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 205

POIDS EXPÉDIÉ / Weight Shipped : 7,40

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

CERTIFICAT

QUANTITÉ EXPÉDIÉE /Quantity Shipped: 205

POIDS EXPÉDIÉ / Weight Shipped : 7,40

Signature:

Date:

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Rapport d'Inspection

Inspection Report

BON DE TRAVAIL order	CHARGEMENT load
308421	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
31271		AL-8061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

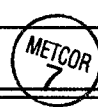
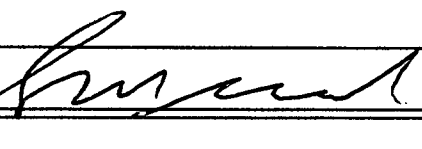
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	38 - 44 %IACS	41	38,5 - 39,5 %IACS
HARDNESS		41	64 - 67 HREW
MESUREE EN HR15TW = 64,5-66,3 HR15TW			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
205	7,4	D4202-1 (205) D4202-1 SPACER
		1 BOITE DE CARTON

17 Feb

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2016-02-16



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31271

Purchase Order Date 2/5/2016

PO Print Date 2/5/2016

Page Number 1 of 2

Order From :
METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

VC-MET004

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
FEB 05 2016

Contact Name
Vendor Phone 450 473 1884

Ship To Contact
Ship To Phone
Ship Via: FedEx Economy collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Exten P
----------	--	------------------------	--------------------------------------	----	--------------------------------	---------------	---------

1	136098	646.9711 BLADE	2/19/2016 Yes 2/19/2016		20.00	\$0.00	\$0
---	--------	----------------	-------------------------------	--	-------	--------	-----

FINISH: HEAT TREAT TO 58-62 RC
ROCKWELL HARDNESS

PART ARE MADE FROM AISI A2 TOOL STEEL

PLEASE NOTE: DETAIL C OF C REQUIRED

2	141110	D4202-1 SPACER	2/19/2016 Yes 2/19/2016		205.00	\$0.00	\$0
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HEAT TREAT TO T4/T42 CONDITION
MIN. UTS=30 KSI (60 HREW MIN)
NOTE: DETAIL C OF C REQUIRED

PART ARE MADE FROM 6061-T6 MATERIAL

Line Total: \$0

Line Total: \$0

Note:

2/5/2016

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
308421	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
31271		AL-6061		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SOL ANNEAL				
SINGLE AGING TO CONDITION T42				
EXIGENCE / requirement				
CONDUCT				
36 - 44 %IACS				
41				
(60kHz)				
38.5 - 39.5 %IACS				
HARDNESS				
41				
64 - 67 HREW				
MESUREE EN HR15TW = 64,5-66,3 HR15TW				
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
205	7.4	D4202-1		
		(205) D4202-1 SPACER		
		1 BOITE DE CARTON		

COMMENTAIRES / comments

REF. 141110

SOL. ANNEAL 529C, 35 MIN
AGE HARDEN AMBIANT, 96 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon

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de commande et le matériel rencontre les exigences spécifiées.

APPROUVÉ par / Approved by:

Isabel Otero
QA Technician

DATE: 2016-02-19

METCOR
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